

Date: Monday, 7/9/2007 2:29:14 PM  
 User: Kim Johnston

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG EXTRUSION		
Job Number	: 33420 -1		Part Number	: D27317		
Estimate Number	: 10326		Drawing Number	: D2731 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/9/2007	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/20/2007		
Previous Run	: 33136		Qty:	100	Um:	Each
Written By				50		
Checked & Approved By						
Comment	: Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 Batch: B23779.			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut D2423 extrusion to .82"			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
 <i>Issue P.O 4191</i> Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
 <i>Receive &amp; Inspect for transit damage</i> <i>EPA 07/08/20 (50)</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC5	SECOND CHECK	
 <i>QSP017</i> <i>Counted</i> Comment: SECOND CHECK <i>Inspect levels 5</i> <i>EP 07/08/22 (X58)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: D Date: 07/08/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: LUG EXTRUSION
Job Number: 33420		Part Number: D27317
Job Number:		
Seq. #:	Machine Or Operation:	Description:
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>M-L</i>  <i>(50x)</i>
7.0	POWDER COATING	POWDER COATING  Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3 <i>M105068</i>  <i>(50)</i> <i>BR/FK</i> <i>07-08-22</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT <i>Er</i> <i>07/08/22</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <i>1/8/22 SP</i>  <i>(50)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE <i>D 070822</i>  <i>(50)</i>
Job Completion		 <i>U 07-08-22</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33420
Description: Lug	Part Number:	D2731-7
Inspection Dwg: D2731      Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

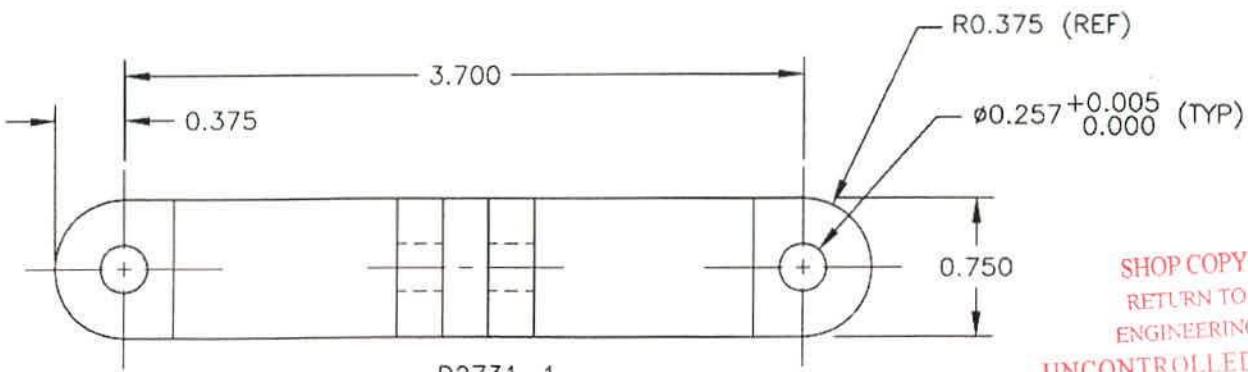
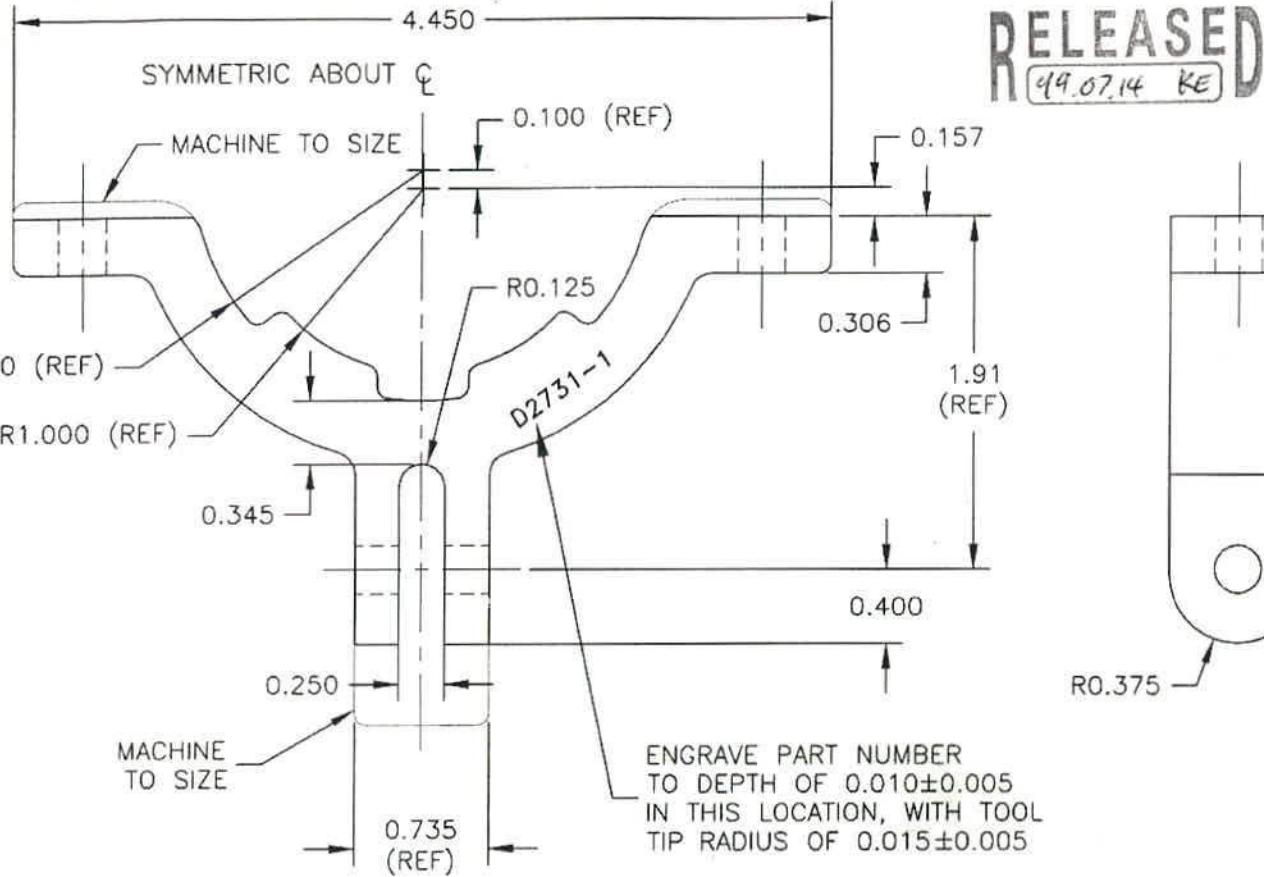
## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF	
B	04.05.06	Dimension change	KJ/RF	FF

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JX</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 1 OF 4
		TITLE MOUNTING LUG
A	98.05.13	SCALE 1:1
B	99.07.06	REVISED DIMENSIONS

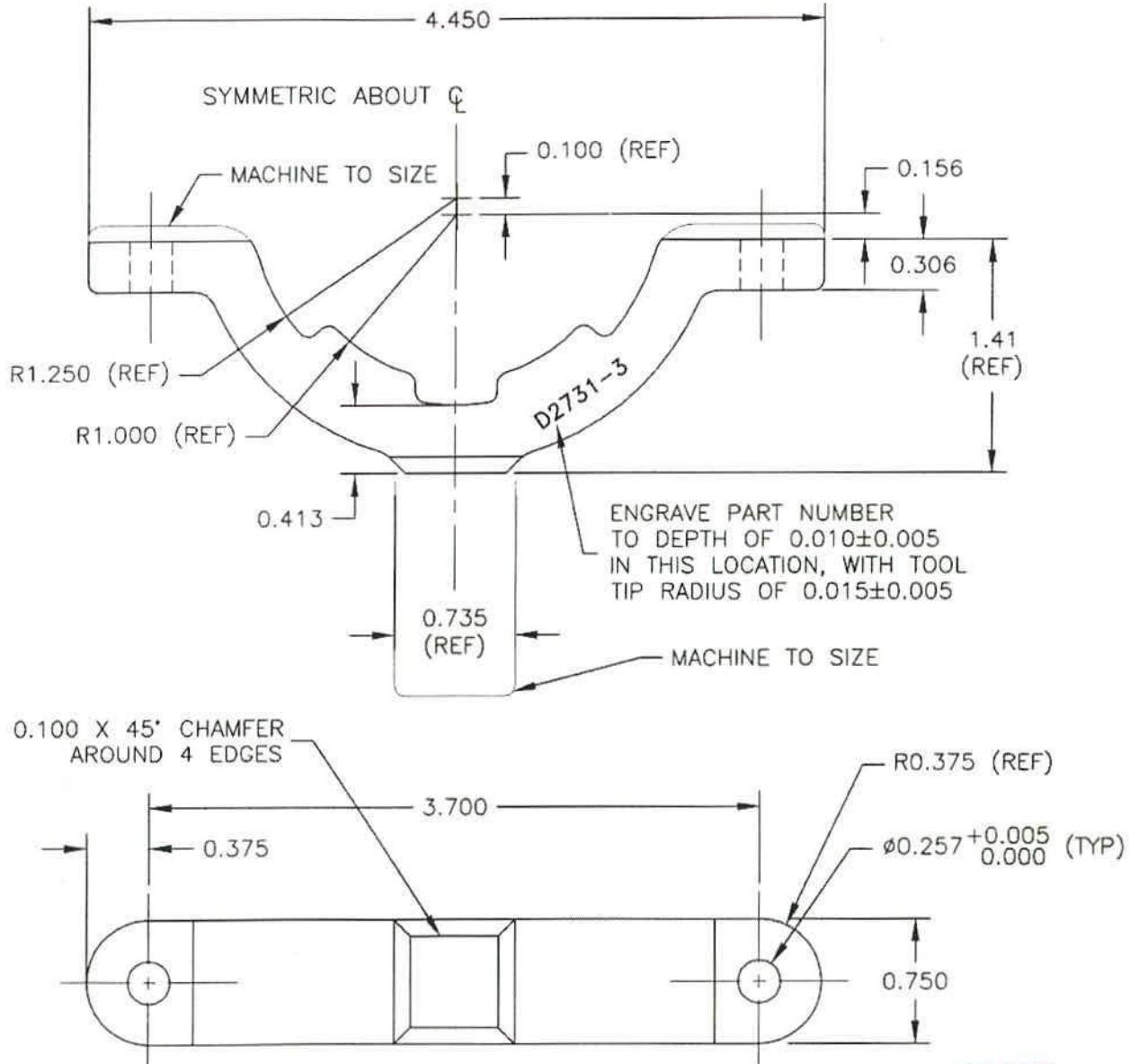


MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33420

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 TITLE MOUNTING LUG SCALE 1:1

**RELEASED**  
19.07.14 KE

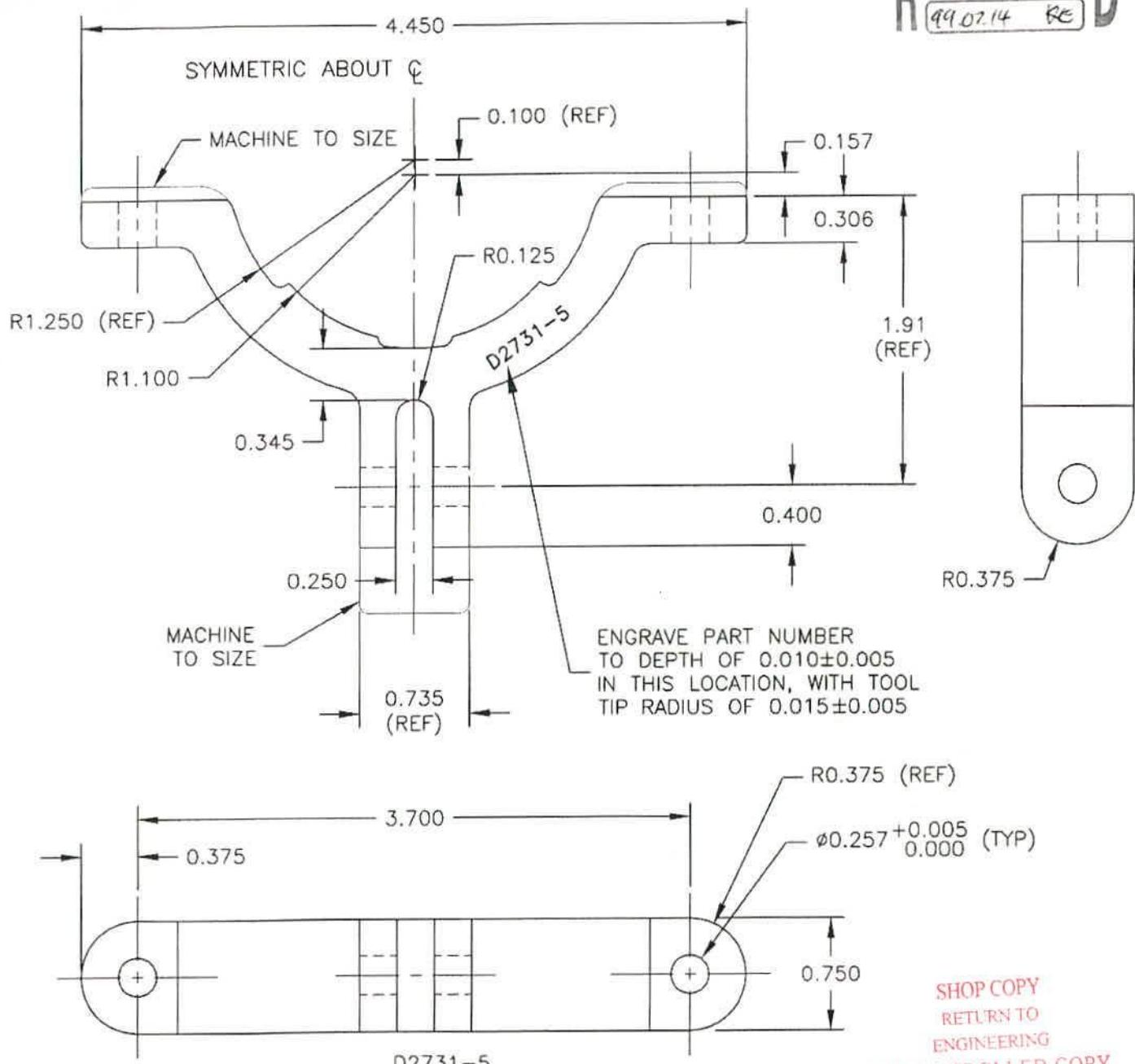
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 334120

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>QS</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 3 OF 4 TITLE MOUNTING LUG SCALE 1:1

**RELEASED**  
99.07.14 *RE*



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

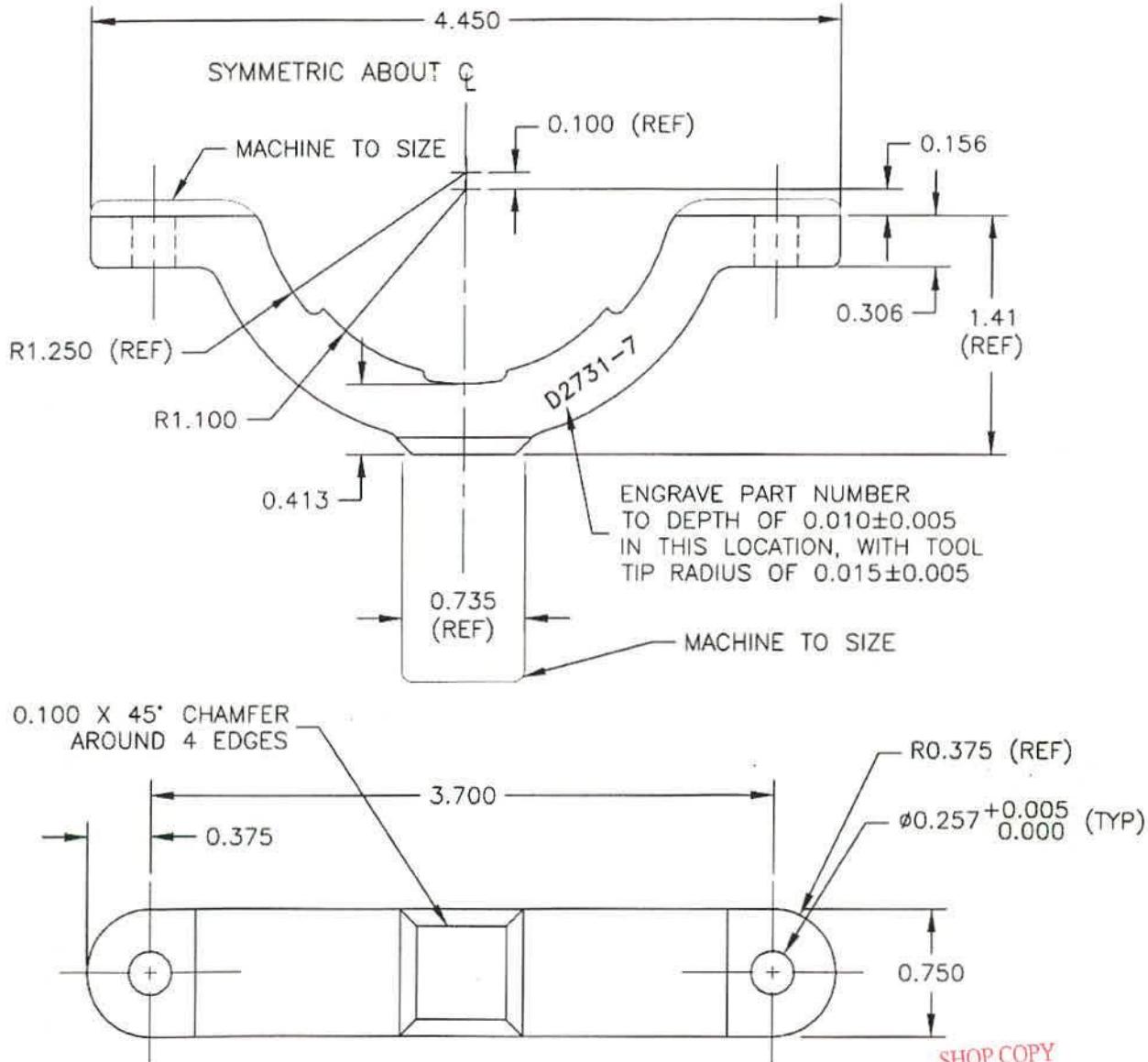
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 NO. *33420*  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>S</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 4 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED  
99.07.14 KE

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000–0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33420



## CERTIFICATE OF CONFORMITY

SHIPPED TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D2731-7

Lug B33420

4191

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in blue ink, appearing to read "Shig Walz".

Vankleek Hill, August 20, 2007

Two handwritten signatures in blue ink. The top one is a stylized "EP". The bottom one is "M08/02".

**METEC** METAL TECHNOLOGY INC.

20 Terry Fox Drive  
 Vankeek Hill, Ontario K0B 1R0  
 Tel: (613) 678-3957  
 Fax: (613) 678-3956

Delivery Slip No.: 16102  
 Date: Aug 20, 2007  
 Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd.  Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4191	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG B33420 MATERIAL SUPPLIED BY DART D2423 B23779	Each	100	50	50

*EJ 07/08/20*

Received by \_\_\_\_\_

Thank you for your order!